

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000375**Date Inspected:** 16-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** PQR#HP-2007 149-1**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Quality Assurance Inspector Brannon periodically observed ZPMC welder Mr. Zhuhai Ping, welding root and fill passes for Procedure Qualification Record Test (PQR) #HP-2007 149-1. Mr. Ping was observed welding in the 3G (vertical), position utilizing a shielded metal arc welding (SMAW) process using a 4.0mm diameter electrode, classification E7018-1, Brand: THJ506Fe-1, manual process. Mr. Ping appeared to be using proper inter-pass cleaning methods by using manual steel wire brush, and manual chisel and hammer. After the second pass had been finished Mr. Ping welded run off tabs to the top of the plate. QA Inspector observed preheat and welding parameters measured by the QC Inspector Mr. Huang Wei. Mr. Wei was assisted by Mrs. Mung and Mr. Jun. Also, observing Mr. Ping welding was American Bridge/Fluor Quality Control Inspector (QC) Mr. Danny McDonald in the morning and QC Inspector Mr. Song Weimin in the afternoon. Welder Mr. Zhuhai Ping deposited eight weld passes on this date.

The following digital photograph illustrates Mr. Zhuhai Ping in the process of welding pass #4 using a (SMAW) process for (PQR test ID#HP-2007-149-1

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Summary of Conversations:

QC Inspector Mr. Wei informed QA Inspector Brannon welding will not be completed today and will resume tomorrow.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
